

Work Order ID 76598

76598

Page 1

November-18-11 9:12:31 AM

Item ID: D206-642-151

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 11/11/18 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

0.00

100

100

DC

Document Control


DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100

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Stop *NS2*

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Start Date: 18/11/2011 Start Qty: 1.00

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Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M119712/M117889 7 BE 12-01-03

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

{SAD 12-01-02

12/01/03

12/01/04

Dart Aerospace Ltd

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill #30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.

****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

S 12/01/04

DC 12/01/04

W/O:		WORK ORDER CHANGES					
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 Required Date: 16/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

DE 12/01/04

DP 12-1-4

DE 12/01/04

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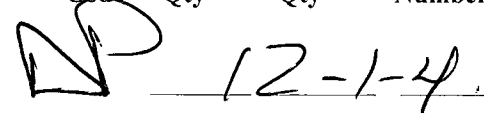
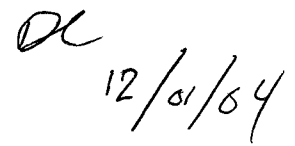
76598

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
180 *180* Skidtubes Skidtubes	Skidtubes Memo 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting Start Date: <u>12/01/04</u> Time: <u>2:20</u> Finish Date: <u>12-01-05</u> Time: <u>8:30</u> Pick: Qty Part Number Description Batch A/RSikaflex-291 119508 Sikaflex expire date: <u>12/08/13</u>	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 76598***76598***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

1 0 8612-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100Setup Start ***NS1***

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Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00

2000

Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod M119785

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE 12-01-05

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 12-01-05DD 12-1-5DD 12-1-5

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
240 *240* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							
250 *250* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00							

START TIME: 1:45
 OVEN TEMPERATURE: 320°F
 FINISH TIME: 2:15

m119480

1X4 m/l 12/04/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260						1 WH	q	lll	12/01/12
QC	Memo	0.00							
Quality Control									
270	HandFinishing	0.00							
270						1 WH	q	lll	12/01/12
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

W/O:		WORK ORDER CHANGES					
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Required Date: 16/01/2012 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280

0.00

280

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

✓ 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/RSikaflex-291 11/11/08Sikaflex expire date: 12/08

✓ 2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: 1111409612/11/11 12/01/16

290

0.00

290

QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

8 12/01/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300 *300* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
310 *310* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-151 Location: _____ PPP Rev: _____	0.00 0.00							
320 *320* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

8/12/11/14

PP7 5764

12/1/16

12/1/17

12-01-17

Dart Aerospace Ltd

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Picklist Print

Page 1

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Work Order ID: 76598

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	14.0000	1	1			
D2620									**			SAD	12-01-02
Skidtube, 206 Skidtube													

Location	Loc Qty	Loc Code
LG	14	
71616	3	
71617	6	
74459	2	
74460	3	B76819

D2647		Manufactured	No			110	Each	253.0000	1	1			
D2647									**				8E12-01-03
Cap													

Location	Loc Qty	Loc Code
LG002	253	
55352	3	
71171	1	
73826	139	
75482	110	

W/O:		WORK ORDER CHANGES					
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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

15,860.00

52

52

CR3212-4-04

Cherry Rivet

**

DL 12/01/04

Location

Loc Qty

Loc Code

ST331

5870

116471

78

117816

3

118686

1

118840

16

119017

5762

119075

10

st510

9990

119075

9990

(54)

D2654-1

Manufactured

No

180

Each

4.0000

1

1

D2654-1

Web

**

DL 12/01/04

Location

Loc Qty

Loc Code

LG

4

73794

1

73799

1

75475

1

75477

1

(1)

D3286-1

Manufactured

No

180

Each

175.0000

2

2

D3286-1

Doubler

**

DL 12/01/04

Location

Loc Qty

Loc Code

LG002

175

74111

1

74441

4

74872

59

75484

111

(2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

November-18-11 9:12:35 AM

Work Order ID: 76598

76598

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 200 Each 461.0000 19 19

D2649

Cross Bolt Spacer

BL-12-01-05
*B 76793 *19*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	134	
68224	2	
71355	2	
72704	2	
72841	11	
73855	117	
LG001	327	
65317	1	
68507	11	
73390	8	
73857	21	
73858	282	
73860	4	

D3286-3 Manufactured No 200 Each 153.0000 2 2

D3286-3

Spacer

BL-12-01-05
*B 76773 *2*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	72	
74870	72	
LG001	1	
74117	1	
LG002	80	
75483	80	

Dart Aerospace Ltd

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November-18-11 9:12:35 AM

Work Order ID: 76598

76598

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210 Each 46.0000 1 1

D2680-041

Nut Plate

**

DP 12-1-5

Location

Loc Qty

Loc Code

LG 75479 1
73334 1
ST020 45
73854 45

①

CR3212-4-03 Purchased No

210 Each 1,904.000 2 2

CR3212-4-03

Cherry Rivet

**

DP 12-1-5

Location

Loc Qty

Loc Code

FB 2
110139 2
ST331 1902
114859 902
119017 1000

②

AN960JD416 NAS1149D0463 Purchased No

210 Each 0.0000 1 1

AN960JD416

Washer

**

M118384 x1 M126112

CCR264SS3-3 Purchased No

210 Each 1,163.000 2 2

CCR264SS3-3

Cherry Rivet

**

DP 12-1-5

Location

Loc Qty

Loc Code

FP 2
113973 2
ST311 187
117849 187
ST317 974
119017 974

②

W/O:		WORK ORDER CHANGES					
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Picklist Print

November-18-11 9:12:35 AM

Page 5

Work Order ID: 76598

76598

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

384.0000

1

1

MS27039-4-06

Screw

**

Jul 12/01/12

Location

Loc Qty

Loc Code

ST291

384

119075

384

D2651-1

Manufactured

No

270

Each

745.0000

6

6

D2651-1

Plug

**

Jul 12/01/12

Location

Loc Qty

Loc Code

FP

745

57869

1

66445

10

69018

2

70839

2

71037

31

73827

699

D2651-3

Manufactured

No

270

Each

1,235.000

6

6

D2651-3

O-Ring

**

Jul 12/01/12

Location

Loc Qty

Loc Code

FP

1235

61962

12

73489

223

73828

1000

x/6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

November-18-11 9:12:35 AM

Page 6

Work Order ID: 76598

76598

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

280 Each 821.0000 14 14

D3873-1

Bushing

**

1376792 (x14) JH 12/01/12

Location

Loc Qty

Loc Code

ST088

821

64760

1

68247

4

73829

19

73830

16

73832

400

75481

381

D2646 Manufactured No

280 Each 235.0000 1 1

D2646

Aft Cap

**

JH 12/01/12

Location

Loc Qty

Loc Code

FP002

218

73294

20

73825

198

FP004

8

68280

5

70945

1

71070

2

FP005

4

71038

4

FP006

5

62678

5

D3805-041 Manufactured No

280 Each 1.0000 1 1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

1376774 (x1) JH 12/01/12

Location

Loc Qty

Loc Code

FP001

1

74893

1

November-18-11 9:12:35 AM

Shop Packet Print

Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 7

November-18-11 9:12:35 AM

Work Order ID: 76598

76598

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,747.000

2

2

MS27039-1-08

Screw

**

all 12/01/12

Location

Loc Qty

Loc Code

ST291

1747

117423

117

118378

130

118910

500

119075

500

119109

500

x2

MS21042L3

Purchased

No

280

Each

8,753.000

7

7

MS21042L3

Nut

**

all 12/01/12

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2498

119075

2498

x7

D3805-045

Manufactured

No

280

Each

5.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

076781 (x1) all 12/01/12

Location

Loc Qty

Loc Code

FP

5

73817

1

74896

1

74938

3

November-18-11 9:12:35 AM

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Page 7

Dart Aerospace Ltd

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Work Order ID: 76598

76598

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332I Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

**

11/11/2011 04:21 11/12/2011

AN3-37A Purchased

No

280

Each

1,966.000

7

7

AN3-37A

Bolt

**

11/12/2011 12:01/12

Location

Loc Qty

Loc Code

ST354

4

117619

4

ST518

1962

119086

1962

17

NAS1149D0363J Purchased

No

280

Each

4,434.000

7

7

NAS1149D0363J

Washer

**

11/12/2011 12:01/12

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968

1214

17

W/O:		WORK ORDER CHANGES					
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ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76598 H.L.J

11/11/18

RELEASED
UP 09.03.03
per ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 1 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

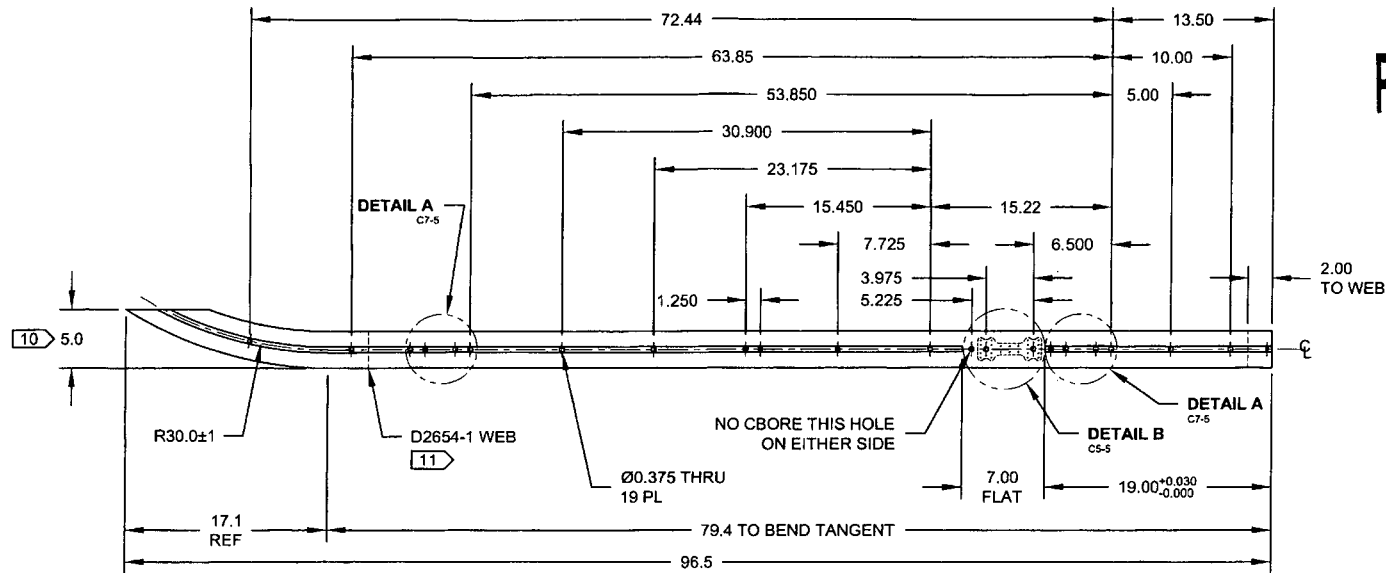
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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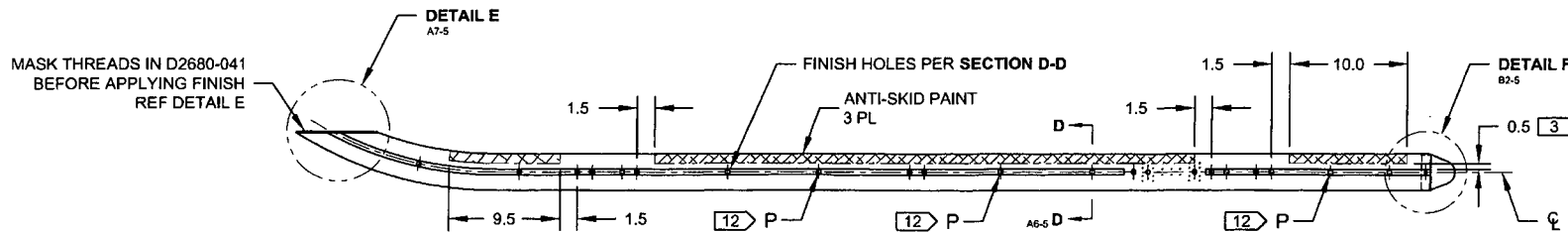
NOTE: Date & initial all entries

76598

RELEASED
09.03.07



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	9	DART AEROSPACE USA, INC	
DRAWN	9	PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	9	D3804	SHEET 2 OF 5
APPROVED	9	TITLE	SCALE
DE APPR.	9	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASE
09.03.03



DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 3 OF 3
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NT
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

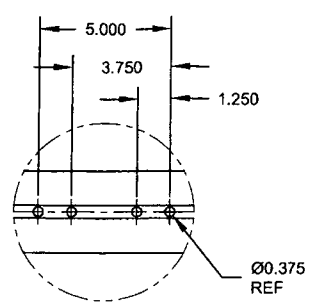
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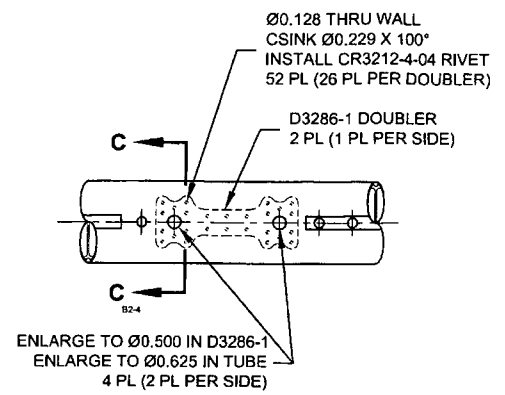
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UP 09.03.07

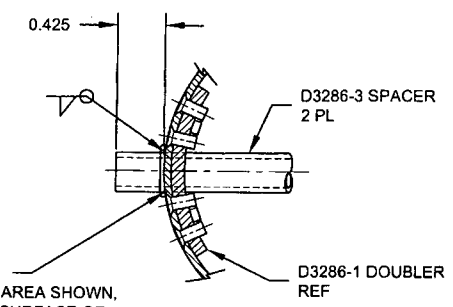


DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

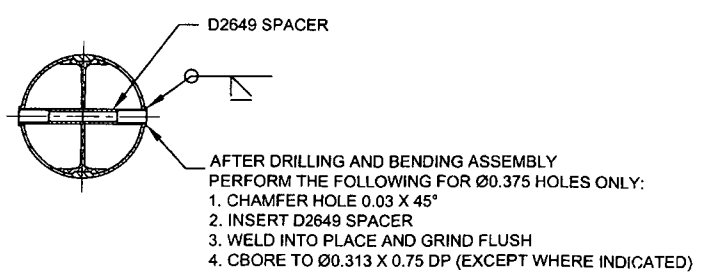


DETAIL B
SCALE NONE
C3-2
C3-3

- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH



SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	Φ	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 4 OF 5
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Dart Aerospace Ltd

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76598

RELEASED
97 09.03.03

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G
SCALE NONE

AT-5

D2647 CAP. TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

MS27039-4-06 SCREW
AN960JD416 WASHER

D2680-041
NUTPLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

1/16

DETAIL E
SCALE NONE

B7-2
B7-3

0.400

END OF WEB

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

DETAIL F
SCALE NONE

B2-2
B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

NO. 278

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 766119
Part number: 206-642-151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sal Dunn Date of Test Coupon 11-12-20
Welder Barclay Elliot Date of Test Coupon 11-12-20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld